

Work Order ID 147111

June 01, 2016 1:37:06 PM

147111

Page 1

Item ID: D3948-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Plate, Anchor

Stop *NS2*

Start Date: 6/2/2016 Start Qty: ~~15.00~~ *15*

Required Date: 6/6/2016 Req'd Qty: 15.00 *15*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: St Date: 20160601

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3948	B								

100 0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.08

1-Cut as per Dwg D3948-1

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.03

15 PR OG/02/2016

15 PR 16-6-2

DAG
19
9-09

H/FC

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Item ID: D3948-041

Revision ID:

Item Name: Plate, Anchor

Start Date: 6/2/2016

Start Qty: 15.00

15

Required Date: 6/6/2016

Req'd Qty: 15.00

15

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.05

Quality Control

15

36
9-89

JUN 03 2016

130

130

Small Fab

Small Fab

Memo

1- countersink holes as per dwg

2- deburr if necessary

0.00

0.10

15X

DAS
36
9-89
16/06/06

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.05

15

DAS
36
9-89

JUN 07 2016

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Item ID: D3948-041

Accept

Revision ID:

N900040100

Item Name: Plate, Anchor

Setup Start

NS1

Start Date: 6/2/2016 Start Qty: 15.00

15

Stop

NS2

Required Date: 6/6/2016 Req'd Qty: 15.00

15

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

Hand Finish

Memo

0.05

Hand Finishing

13a / 11/10/16

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.03

Quality Control

13

DAS
36
9-89

JUN 09 2016

170

Pick Kit

0.00

170

Packaging

Memo

0.00

Packaging

2x

16/06/16
DAS
36
9-89

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Page 4

Accept

Revision ID:

N900040100

Setup Start *NS1*

Item Name: Plate, Anchor

Stop *NS2*

Start Date: 6/2/2016 **Start Qty:** 15.00

15

Required Date: 6/6/2016 **Req'd Qty:** 15.00

15

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							

180

Small Fab

Small Fab

Memo

INSTALL NUT PLATES AS PER DWG

190

QC5- Inspect part completeness to step on W/O	0.00
---	------

190

QC

Quality Control

Memo

0.05

DAS
36
9-89

JUN 16 2016

200

Identify as per dwg & Stock Location: STOCK 0.00

200

Packaging

Packaging

Memo

0.03

DAS
26
9-89

JUN 29 2016

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Item ID: D3948-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Plate, Anchor

Stop *NS2*

Start Date: 6/2/2016 Start Qty: 15.00 *15*

Cust Item ID:

Required Date: 6/6/2016 Req'd Qty: 15.00 *15*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21 - Final Inspection - Work Order Release

0.00

210

QC

Memo

0.25

Quality Control

MJS JUN 20 2016

Picklist Print

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Page 1

Work Order ID: 147111

147111

Parent Item: D3948-041

D3948-041

Parent Item Name: Plate, Anchor

Start Date: 6/2/2016

Required Date: 6/6/2016

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	765.0000	0.1085	1.713158			

M6061T6S 063

6061-T6 .063 Sheet

PA 06/02/2016

Location	Loc Qty	Loc Code
MAT021	429	
M133511	4	
M134377	4.9	
M134830	420.1	2.1
TPI	336	
M134496	192	
M134604	144	

MS21059L3

Purchased No

170 Each

139.0000

2

30

MS21059L 3

Nut Plate

16/06/16 36 89

Location	Loc Qty	Loc Code
CA	8	
M129682	8	
GA	18	
M133990	18	
ST301	87	
M134257	17	
M134762	70	27
ST303	26	
M133016	26	

M135015
(3)

Picklist Print

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Work Order ID: 147111

Parent Item: D3948-041

Parent Item Name: Plate, Anchor

147111

D3948-041

Start Date: 6/2/2016

Required Date: 6/6/2016

Start Qty: 15.00

Required Qty: 15.00

MS20426AD3-3

Purchased

No

170

Each

1,777.000

4

60

MS20426AD3-3

RIVET

16/06/10 DAS
36
9-89

Location

Loc Qty

Loc Code

GA

710

M131624

710

ST312

1067

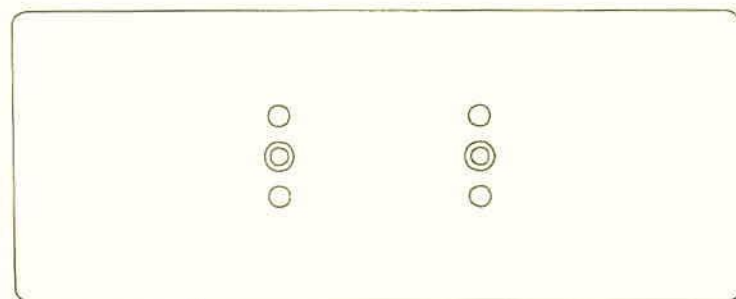
M131624

1067

60

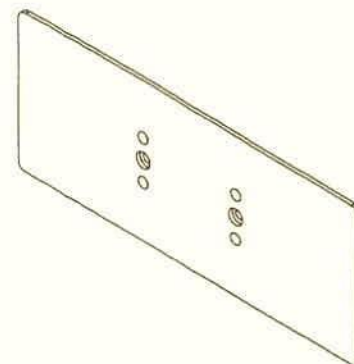
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-041	PLATE, ANCHOR
2	1	D3948-1	PLATE
3	2	MS21059L3	NUTPLATE (OR MS21059-3)
4	4	MS20426AD3-3	RIVET

D3948-041 PLATE, ANCHOR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs



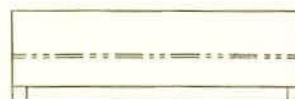
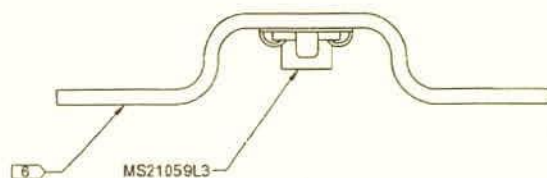
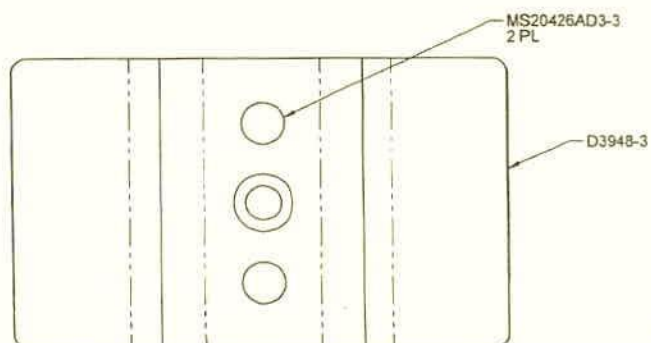
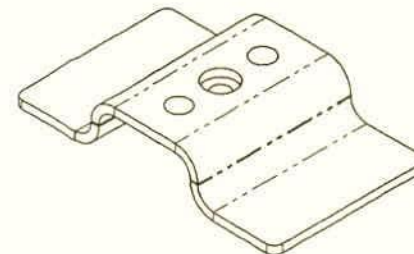
20160601

S4
147111RELEASED
09/06/08

B	-3F NOW MADE FROM 304 SS (ZN AB-5), 0.063 THICK WAS 0.040 (ZN AB-3, AB-5), -043/-3/-3F WIDER (ZN BG-4, BG-5)	CP	09.06.08
A	NEWISSUE	CP	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	921	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	921		
CHECKED	2/3	DRAWING NO.	REV. B
MFG. APPR.	2/3	D3948	SHEET 1 OF 5
APPROVED	2/3	TITLE	SCALE
DE APPR.	2/3	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED FOR THE EXPRESS COMMERCE THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

PARTS LIST

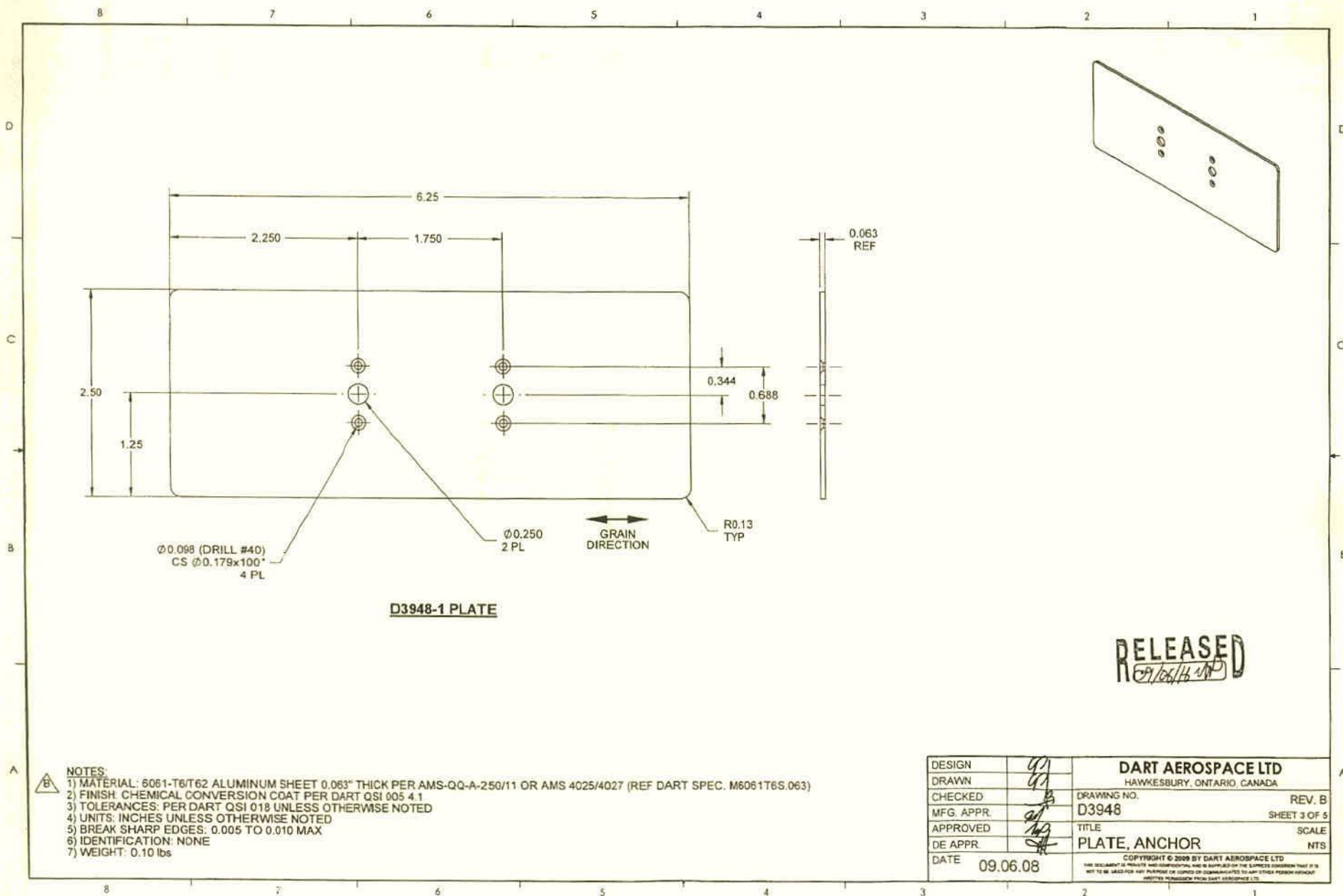
ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-043	PLATE, ANCHOR
2	1	D3948-3	PLATE
3	1	MS21059L3	NUTPLATE (OR MS21059-3)
4	2	MS20426AD3-3	RIVET

D3948-043 PLATE, ANCHORRELEASED
07/06/10

NOTES:

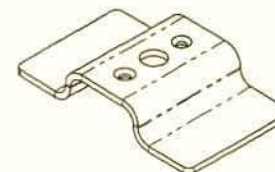
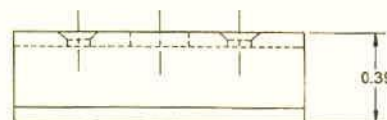
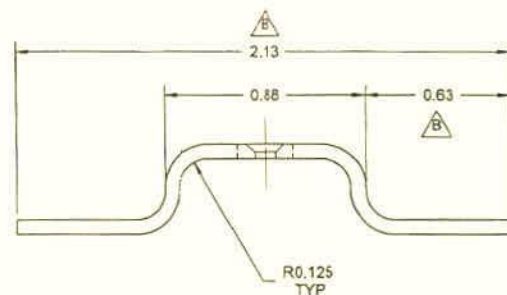
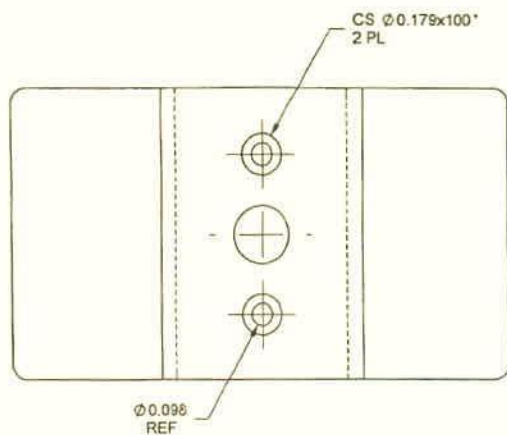
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

DESIGN	901	DART AEROSPACE LTD	
DRAWN	901	HAWKESBURY, ONTARIO, CANADA	
CHECKED	901	DRAWING NO.	REV. B
MFG. APPR	901	D3948	SHEET 2 OF 5
APPROVED	901	TITLE	SCALE
DE APPR.	901	PLATE, ANCHOR	NTS
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- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063" THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.10 lbs

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D3948	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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D3948-3 PLATE

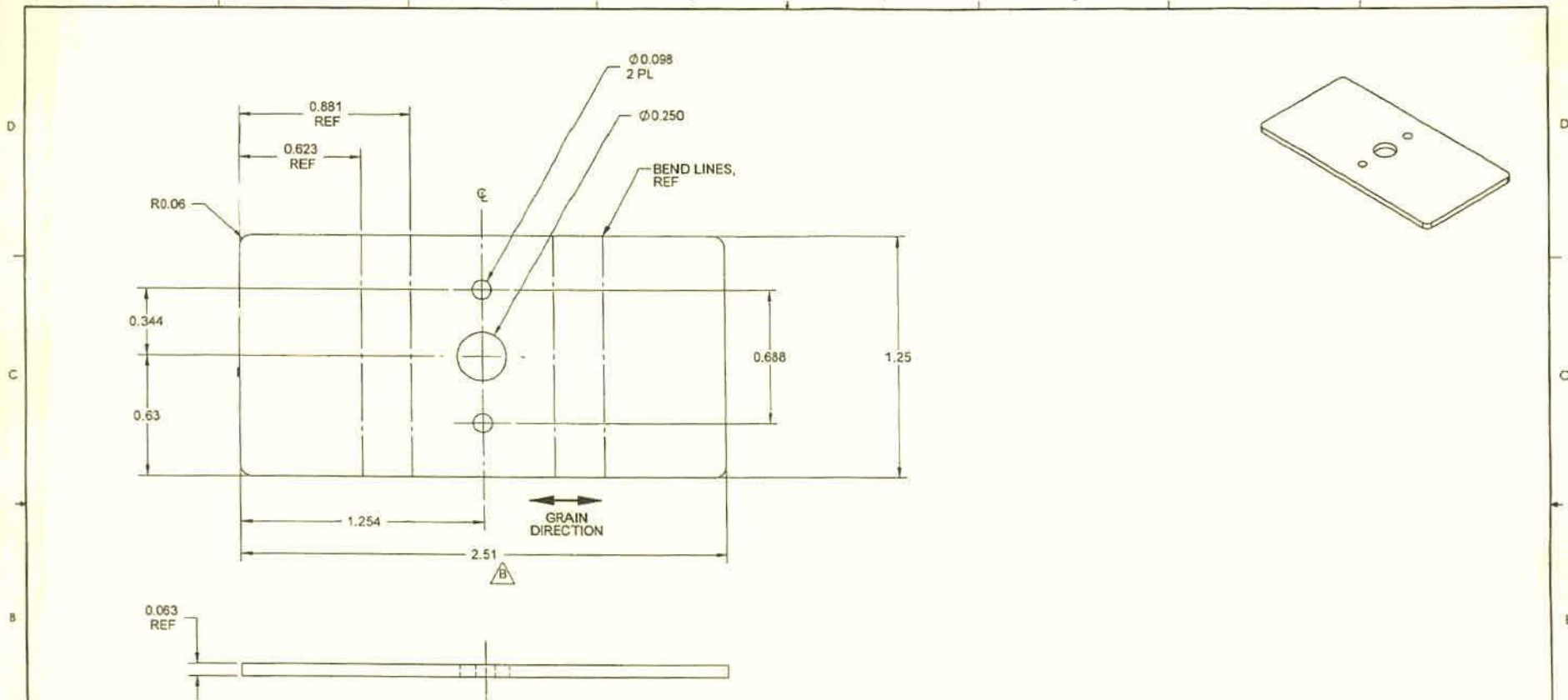
RELEASED
5/16/16

NOTES:

- 1) MATERIAL: MAKE FROM D3948-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

DESIGN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	97			
CHECKED	97		DRAWING NO.	REV. B
MFG. APPR.	97		D3948	SHEET 4 OF 5
APPROVED	97		TITLE	SCALE
DE APPR.	97		PLATE, ANCHOR	NTS
DATE	09.06.08		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D3948-3F PLATE

RELEASED
9/16/16

- NOTES:
- 1) MATERIAL: AISI 304 SS SHEET 0.063" THICK (REF DART SPEC. M304S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

DESIGN	<i>gcl</i>	DART AEROSPACE LTD	
DRAWN	<i>gcl</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>gcl</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>gcl</i>	D3948	SHEET 5 OF 5
APPROVED	<i>gcl</i>	TITLE	SCALE
DE APPR.	<i>gcl</i>	PLATE, ANCHOR	NTS
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8 7 6 5 4 3 2 1

